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RBW6510G05731-6F
Job Sheet 198992



Part No: RBW6510G05731-6F

Job Qty: 2 pcs

Part Name: Support Base Removal/Installation Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/8/19

Job Tracking No:

Due Date: 10/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6510G05731-6F Rev A IPP Rev. A 19.08.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

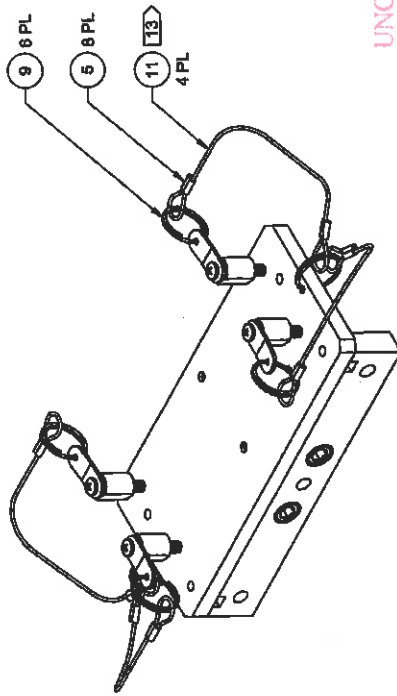
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	10/22/19		0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	2 pcs	10/22/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		68-8
							QC 5 - 40		OCT 3 0 2019 07
							QC 5 - 61		DAS
							QC 5 - 81		
120	Packaging 3-1 - Stock - B4B	2 pcs	10/22/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		DAS
							Packaging 3 - 4 - B4B		28
							Packaging 3 - 5 - B4B		9-89
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		DAS
							Packaging 3 - 10 - B4B		21
130	QC 21 - FG	2 pcs	10/22/19		0.00	0.00	QC 21 - FG - 21		9-39
							QC 21 - FG - 70		
							QC 21 - SA - 53		OCT 3 1 2019

Part Op 100 - Assemble as per DWG. See note 8 through 13.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
 130 - QC21- Final Inspection - Work Order Release

Job BOM					012715
Part / Item	Component Name	Quantity	Operation	Container	
3896T31	Ferule 1/16 X 3/8" - Aluminum 26	16 Ea (8 ea)	100-Small Fab	- 1	215202
90128A364	3/8 Fine Thread Bolt 65	4 Ea (2 ea)	100-Small Fab	- 1	5206640
90128A376	Zinc Plated Steel Socket Head Screw 1/4"-28 X 1-1/4" Long 65	4 Ea (2 ea)	100-Small Fab	- 1	5206699
90272A829	Screw #10-32 63	8 Ea (4 ea)	100-Small Fab	- 1	108573
90905A655	316 SS Split Ring 15/16" ID. X 1-1/16" OD. X 1/8" Thick 5864	12 Ea (6 ea)	100-Small Fab	- 1	223364
97840A460	18-8 SS Tab For Wire Rope Lanyard 1.40" Long X 1/2" Width X 1/16" Thick 58	8 Ea (4 ea)	100-Small Fab	- 1	192675
CL-2-C	Lanyard Wire -	4 ft (2 ea)	100-Small Fab	- 1	102012
RBW6510G05731-6F-1 Base Plate 215		2 pcs (1 ea)	100-Small Fab	- 1	5216747
RBW6510G05731-6F-2 Support 216		2 pcs (1 ea)	100-Small Fab	- 1	215790
RBW6510G05731-6F-3 Reaction Mount 216		2 pcs (1 ea)	100-Small Fab	- 1	217081
RBW6510G05731-6F-4 Pin 215		2 pcs (1 ea)	100-Small Fab	- 1	220014 220014
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Small Fab - 1	3896T31	16	704	0	
	90128A364	4	0	0	
	90128A376	4	0	0	
	90272A829	8	100	0	
	90905A655	12	16	0	
	97840A460	8	25	0	
	CL-2-C	4	1,168	0	
	RBW6510G05731-6F-1	2	0	0	
	RBW6510G05731-6F-2	2	0	0	
	RBW6510G05731-6F-3	2	0	0	
	RBW6510G05731-6F-4	2	0	0	
Part Specifications					
Specifications could not be found.					

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ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6510G05731-8F-1	BASE PLATE SUPPORT
-2	1	RBW6510G05731-8F-2	REACTION MOUNT
-3	1	RBW6510G05731-8F-3	PIN
-4	4	RBW6510G05731-8F-4	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
5	8	McMaster#3896T31 OR EQUIV.	ZINC PLATED STEEL SOCKET HEAD SCREW 3/8"-24 X 1" LG.
6	2	McMaster#90128A364 OR EQUIV.	ZINC PLATED STEEL SOCKET HEAD SCREW 1/4"-28 X 1-1/4" LG.
7	2	McMaster#90128A378 OR EQUIV.	ZINC PLATED STEEL PAN HEAD PHILLIPS SCREW #10-32 X 1/2" LG.
8	4	McMaster#90272A829 OR EQUIV.	3/16 SS SPLIT RING 15/16" ID. X 1-1/16" OD. X 1/8" THK.
9	8	McMaster#90805A655 OR EQUIV.	18-8 SS TAB FOR WIRE ROPE LANYARD 1.40" LG. X 1/2" WIDTH. X 1/16" THK.
10	4	McMaster#97640A460 OR EQUIV.	NYLON COATED STEEL LANYARD 1/16" DIA.
11	AR	CARR-LANE#CL-2-C	



RBW6510G05731-8F SUPPORT BASE REM/INSTL. TOOL

NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 1"$
 XXX = $\pm 0.01"$ / $\pm 0.5"$
 XXXX = $\pm 0.005"$ / $\pm 0.1"$
 XXXXX = $\pm 0.0005"$ / $\pm 0.05"$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$ UNLESS OTHERWISE NOTED

5) UNITS: INCHES
 6) IDENTIFICATION: N/A
 7) ASSEMBLY AS SHOWN
 8) APPLY RED THREADLOCKER LOCITE 263282 ON THREADS OF ITEM 1, AND REMOVE EXCESS
 9) APPLY RED THREADLOCKER LOCITE 263282 ON THREADS OF ITEM 2, AND REMOVE EXCESS
 10) APPLY RED THREADLOCKER LOCITE 263282 ON THREADS OF ITEM 3, AND REMOVE EXCESS
 11) INSTALL ITEMS 4 AND 7 HAND TIGHTEN
 12) ITEM 4 MUST ROTATE FREELY UNDER ITEM 10
 13) ASSEMBLED LANYARD LENGTH MUST BE 6" $\pm 1"$ LANYARD MUST MOVE FREELY WHEN INSTALLING/REMOVING ITEM 4
 14) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

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 WORK ORDER
 NO. 198992 MWS
 19-08-05

A		NEW ISSUE		19-806		KPT
REV.	DESIGN	BY	ECN #			
DRAWN	KPT	DART AEROSPACE LTD				
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA				
MFG. APPR.	VM	TOOL PART #				
APPROVED	VP	RBW6510G05731-8F				
DATE		2019-07-09		REV. A		
TITLE		SUPPORT BASE REM/INSTL. TOOL		SHEET 1 OF 6		
SCALE		NTS		REV. A		
DATE		2019-07-09		SHEET 1 OF 6		
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Cross tube ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Finishing ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ Skid-tube ☐ ☐ ☐ Engineering ☐ ☐ ☐ Machining ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Large Fab ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐		MRB (QSI042)	
Date: _____		Sequence #: _____		QTY Affected: _____		Completed By	
Description Work Order Deviation		Disposition		Lead hand / Supervisor		QC / QA Coordinator	
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐		FAULT CATEGORY Pressure/Forced ☐ ☐ ☐ Contamination ☐ ☐ ☐ Bending ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ Crushing ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Cracks ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ Other/Details: _____					
				Power Loss/Surge ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ Weld ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐		Positioned Wrong ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐	